

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017746**Date Inspected:** 03-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen, Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10, OBG BIKE PATH (NWIT # 07211)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A1-029-043

BAY 11, OBG BIKE PATH (NWIT # 07216)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004ASD1-021-001~004, 022~024, 027

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BAY 11, OBG BIKE PATH (NWIT # 07220)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A5-020-112, 115, 118, 121, 122, 125, 128, 131

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 11

OBG BIKE PATH REPAIR, END PLATE REPAIR (B-WR16450)

SMAW welding of weld joint 043 located on BK005B1-004.

Welder is identified as 040655. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-REPAIR.

OBG BIKE PATH, CLOSURE BOX

FCAW welding of weld joints 022~024 & 027 located on BK004ASD1-053.

Welder is identified as 054460. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4c-F.

OBG BIKE PATH, END PLATE

FCAW welding of weld joint 044 located on BK004C1-024.

Welder is identified as 040723. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4c-F.

TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 073B located on ESD1-TL5-2B/F.

Welder is identified as 040699. ZPMC QC is identified as Mr. Xu Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

BAY 10

OBG BIKE PATH, BOTTOM COVER PLATE

During random in process inspection this QA inspector observed that AB/F NDT personnel were performing Magnetic Particle Testing on the weld joints of bottom cover plate of OBG bike path. The members are identified as OBG Components. The weld designations reviewed are as follows.

BK004A2-028-016, 018

OBG BIKE PATH, CENTRE PLATE

FCAW welding of weld joint 024 located on BK004A6-026.

Welder is identified as 052075. ZPMC QC is identified as Mr. Yu Zhi Lai.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

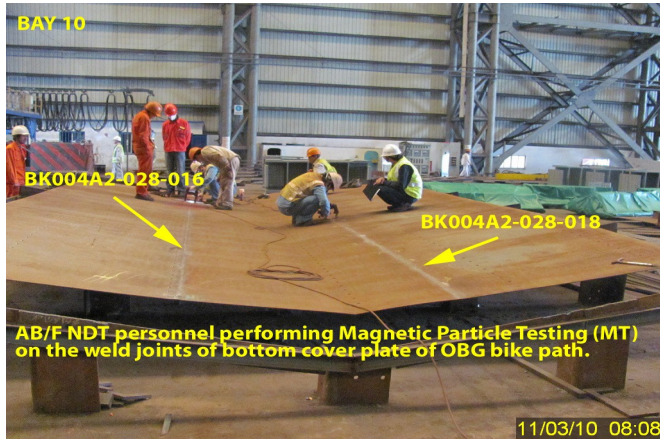
TOWER GRILLAGE COVER PLATE

SAW welding of weld joint 075B located on SSD1-TL5-1B-F.

Welder is identified as 0503060. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-3221-B-U3c-S-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372/ Thomas Ho - 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
